

Work Order ID 118409

118409

Page 1

October-30-14 11:18:21 AM

Item ID: QB21304 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: PUREair Panel Assembly
 Start Date: 10/30/14 Start Qty: 18.00 ***18*** Cust Item ID:
 Required Date: 10/30/14 Req'd Qty: 18.00 ***18*** Customer:
 Reference: REWORK PER RS1025

Approvals: Process Plan: u Date: Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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100		0.00							
100									
Small Fab	Memo	0.00							
Small Fab	PULL FROM STK: 8 X QB21304 M129631 10 X QB21304 M129914 REWORK PER RS1025 STEP 1								

110	QC5- Inspect part completeness to step on W/O	0.00							
110									
QC	Memo	0.00							
Quality Control	INSPECT HOLES, VERIFY DIMENSIONS, CHECK ANCHOR NUT TO ENSURE PART IS FUNCTIONAL								

NOV 13 2014

DAS

9

9-89

Work Order ID 118409

October-30-14 11:18:21 AM

118409

Page 2

Item ID: QB21304 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: PUREair Panel Assembly
Start Date: 10/30/14 Start Qty: 18.00 ***18*** Cust Item ID:
Required Date: 10/30/14 Req'd Qty: 18.00 ***18*** Customer:
Reference: REQORK PER RS1025

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	Touch up alodine	0.00							
120						(15)	14-11-15	DAS 9	
HandFinish	Memo	0.00						9-89	
Hand Finishing									
130	QC7-Inspect Chemical Conversion Coat	0.00							DAS 38 9-89
130							14/10/18		
QC	Memo	0.00							
Quality Control									
140	Spray Painting per QSI005 4.2	0.00							
140						15			CR 14/11/18
SprayPaint	Memo	0.00							
Spray Painting	TOUCH UP PRIMER AS PER QSI005 4.2.1								

Work Order ID 118409

October-30-14 11:18:21 AM

118409

Page 3

Item ID: QB21304 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: PUREair Panel Assembly
 Start Date: 10/30/14 Start Qty: 18.00 ***18*** Cust Item ID:
 Required Date: 10/30/14 Req'd Qty: 18.00 ***18*** Customer:
 Reference: REQORK PER RS1025

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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150	QC14- Inspect Spray Paint	0.00							DAS 9 9-89
150									
QC	Memo	0.00							(15) 14-11-18
Quality Control									

160	QC5- Inspect part completeness to step on W/O	0.00							
160									
QC	Memo	0.00							L DAS 9 9-89 14/11/20 (15)
Quality Control	UPDATE LABEL BY ENGRAVING "A" AGAINST MOD NUMBER								

170	Identify as per dwg & Stock Location: _____	0.00							
170									
Packaging	Memo	0.00							
Packaging	RE-IDENTIFY, USING NEW B.N								

NA
DAS
9
9-89

Work Order ID 118409

October-30-14 11:18:21 AM

118409

Page 4

Item ID: QB21304 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: PUREair Panel Assembly
Start Date: 10/30/14 Start Qty: 18.00 ***18*** Cust Item ID:
Required Date: 10/30/14 Req'd Qty: 18.00 ***18*** Customer:
Reference: REQORK PER RS1025

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							
Quality Control									

14/12/2 DJ

U 14-11-20

DART AEROSPACE LTD	Work Order: 118409
Description: Repair Scheme MOD for ECR38646	
Drawing: QB21502	Repair Scheme: RS1025
Part No: AIR FILTER QB21304	Page: 1 of 1
Batch No: SERIAL #'s: RA5-3455 TO RA5-3464 and RA5-5153 TO RA5-5158	Qty: 1

Step	Location	Procedure	By	Date	Qty
1	SMALL FAB	a) Record Serial Number: QB-21304 RA5-5162 b) Protect filter to ensure debris generated by the repair cannot enter the panel. c) Using a reamer, enlarge 2 off holes 5.1/5.2mm to 6.5 mm +/-0.5mm, per Pall Aerospace ECR38646 attached. d) Ensure reamer has stop installed to prevent damage to anchor nut. e) Clean edge of hole. f) Remove any swarf.	FF	NOV 13 2014	1
2	INSPECTION	a) QC5 inspect holes, verify dimension, check anchor nut to ensure part is functional.	DAS 9 9-89	NOV 18 2014	
3	FINISHING	Touch-up alodine only	DAS 9 9-89	NOV 18 2014	
4	INSPECTION	QC7			
5	PAINT	Touch up primer as per QSI 005 Chapter 4.2.1 Record Batch: _____			
6	INSPECTION	QC14	DAS 9 9-89		
7	INSPECTION	QC5 Inspection Update label by engraving "A" against Mod No.			
8	INSPECTION	QC21			
9	Packaging	Return completed part to original packaging.			

Rev	Date	Change Description	Prepared	Checked	Approved
A	14.10.28	New Issue	DD	PS	

U:\Admin\Forms\RepairschemblA.doc

Rev. A

Approved (Pall Aerospace): Derek Harper
Position: Chief Engineer - Global Air Products

Signed: _____

Date: 29/10/14

Picklist Print

October-30-14 11:18:19 AM

Page 1

Work Order ID: 118409

118409

Parent Item: QB21304

QB21304

Parent Item Name: PUREair Panel Assembly

Start Date: 10/30/14

Required Date: 10/30/14

Start Qty: 18.00

Required Qty: 18.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
QB21304		Purchased			No		Each	0.0000		18			

QB21304

PUREair Panel Assembly

8x M129631

10x M129914

List Lots

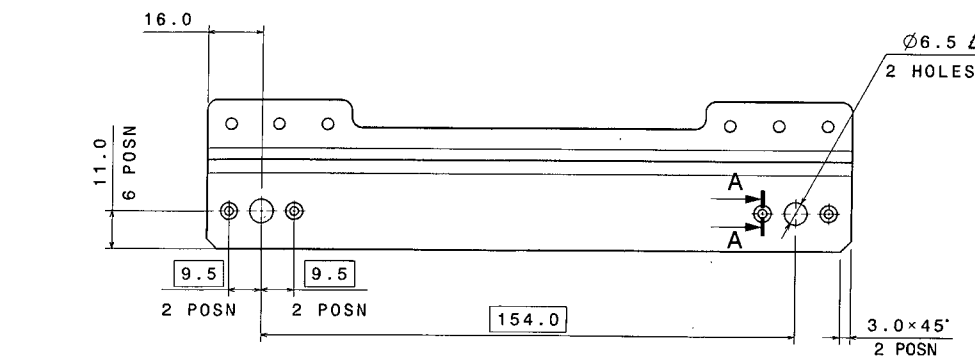
October-30-14 11:10:40 AM

Page 1 of 1

Criteria : Item ID: qb21304 All Locations All Warehouses All Quantity

Item ID	Warehouse ID	Lot Number	Last Trans Date	Lot Qty	Shelf Life Dt	Type Code	Comments
Item Name	Location ID				Lot Code		
QB21304	CONSIGNMENT	m129631	10/08/14	8.0000			
PUREair Panel Assembly	MEZZ2						
	CONSIGNMENT	m129914	7/29/14	10.0000			
	MEZZ2						
			Total:	18.0000			

118409



SCALE: 5:1
TYP 4 POSN

8. PRIME USING REFS 01-03 IN ACCORDANCE
WITH MANUFACTURER'S INSTRUCTIONS TO QD 3088.

PART MARK TO QD5016  1 & 4

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PALL EUROPE LTD

UNLESS OTHERWISE SPECIFIED		
DIMENSIONS ARE IN		
MILLIMETRES		
TOLERANCES ARE:		
DECIMALS	ANGLES	
X. ± 1.0	± 0.5 DEG	
X ± 0.5		
.XX ± 0.25		
.XXX ± -		
SURFACE FINISH	3.2/√	
DO NOT SCALE DRAWING		

THIRD ANGLE
PROJECTION

APPLICATION
NEXT ASSY
QB21504
USED ON
QB05008

10
118409

REF	PART NUMBER	QTY	DESCRIPTION	MATERIAL/REMARKS
01	QD3088-133	A/R	PRIMER EPOXY PR143	---
02	QD3088-134	A/R	CATALYST 143	---
03	QD3088-135	A/R	THINNERS T17	---

SHEET 04	APPROVALS		DATE		 Pall Corporation			
	DRAWN BY	T SMITH	21 AUG 2013		PALL AEROPOWER ENGINEERING. PORTSMOUTH, ENGLAND			
	DRG CHK	S L ROACH	23 AUG 2013					
	PROJ ENG				TITLE BRACKET MOUNTING			
	MFG ENGR							
	TECH APRL							
	DSGN APRL							
DSGN APRL	D P SMITH	27 AUG 2013		SIZE A2	DWG CODE U00B8	DRG NO DB21502	ISS 1AY	
CONTRACT NO				SCALE 1:1	WEIGHT	SHEET A OF A		

PALL Pall Corporation

13	FALL AEROPOWER ENGINEERING.	PORTSMOUTH, ENGLAND
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TITLE	BRACKET MOUNTING
-------	------------------

13	SIZE A2.	CAGE CODE U0086	DRG NO DB21502	ISS 1AY
	SCALE 1:1	WEIGHT	SHEET A OF A	

CAD LOCATION
UKEH CATDRW-131931

DART AEROSPACE LTD		Work Order:	
Description: Repair Scheme MOD for ECR38646			
Drawing: QB21502	Repair Scheme:	RS1025	
Part No: AIR FILTER QB21304	Page:	1 of 1	
Batch No: SERIAL #'s: RA5-3455 TO RA5-3464 and RA5-5153 TO RA5-5158		Qty:	1

Step	Location	Procedure	By	Date	Qty
1	SMALL FAB	a) Record Serial Number: <u>RA5-3456</u> b) Protect filter to ensure debris generated by the repair cannot enter the panel. c) Using a reamer, enlarge 2 off holes 5.1/5.2mm to 6.5 mm +/-0.5mm, per Pall Aerospace ECR38646 attached. d) Ensure reamer has stop installed to prevent damage to anchor nut. e) Clean edge of hole. f) Remove any swarf.	<i>[Signature]</i>	14-11-18 14-11-18	1
2	INSPECTION	a) QC5 inspect holes, verify dimension, check anchor nut to ensure part is functional.			
3	FINISHING	Touch-up alodine only			
4	INSPECTION	QC7			
5	PAINT	Touch up primer as per QSI 005 Chapter 4.2.1 Record Batch: <u>128 927</u>	<i>[Signature]</i>	14-11-18 14-11-18	1
6	INSPECTION	QC14			
7	INSPECTION	QC5 Inspection Update label by engraving "A" against Mod No.			
8	INSPECTION	QC21			
9	Packaging	Return completed part to original packaging.			

Empty Box

Rev	Date	Change Description	Prepared	Checked	Approved
A	14.10.28	New Issue	DD	PS	

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Rev. A

Approved (Pall Aerospace): Derek Harper
Position: Chief Engineer – Global Air Products

Signed: *[Signature]* Date: 27/10/14

DART AEROSPACE LTD	Work Order:	
Description: Repair Scheme MOD for ECR38646		
Drawing: QB21502	Repair Scheme:	RS1025
Part No: AIR FILTER QB21304	Page:	1 of 1
Batch No: SERIAL #'s: RA5-3455 TO RA5-3464 and RA5-5153 TO RA5-5158	Qty:	1

Step	Location	Procedure	By	Date	Qty
1	SMALL FAB	a) Record Serial Number: <u>RA5-3457</u> b) Protect filter to ensure debris generated by the repair cannot enter the panel. c) Using a reamer, enlarge 2 off holes 5.1/5.2mm to 6.5 mm +/-0.5mm, per Pall Aerospace ECR38646 attached. d) Ensure reamer has stop installed to prevent damage to anchor nut. e) Clean edge of hole. f) Remove any swarf.	FF	NOV 13 2014	1
2	INSPECTION	a) QC5 inspect holes, verify dimension, check anchor nut to ensure part is functional.	DAS 9 9-89	NOV 18 2014	
3	FINISHING	Touch-up alodine only	DAS 9 9-89	NOV 18 2014	
4	INSPECTION	QC7	W		
5	PAINT	Touch up primer as per QSI 005 Chapter 4.2.1 Record Batch: <u>128 927</u>	ep	14.11.18	1
6	INSPECTION	QC14	DAS 9 9-89	14.11.18	1
7	INSPECTION	QC5 Inspection Update label by engraving "A" against Mod No.	CL	14/11/20	1
8	INSPECTION	QC21			
9	Packaging	Return completed part to original packaging.			

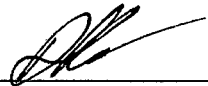
Rev	Date	Change Description	Prepared	Checked	Approved
A	14.10.28	New Issue	DD	PS	

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Rev. A

Approved (Pall Aerospace): Derek Harper
Position: Chief Engineer - Global Air Products

Signed:



Date:

29/10/14

DART AEROSPACE LTD	Work Order:	
Description: Repair Scheme MOD for ECR38646		
Drawing: QB21502	Repair Scheme:	RS1025
Part No: AIR FILTER QB21304	Page:	1 of 1
Batch No: SERIAL #'s: RA5-3455 TO RA5-3464 and RA5-5153 TO RA5-5158	Qty:	1

Step	Location	Procedure	By	Date	Qty
1	SMALL FAB	a) Record Serial Number: <u>RA5-3459</u> b) Protect filter to ensure debris generated by the repair cannot enter the panel. c) Using a reamer, enlarge 2 off holes 5.1/5.2mm to 6.5 mm +/-0.5mm, per Pall Aerospace ECR38646 attached. d) Ensure reamer has stop installed to prevent damage to anchor nut. e) Clean edge of hole. f) Remove any swarf.	FF	NOV 13 2014	1
2	INSPECTION	a) QC5 inspect holes, verify dimension, check anchor nut to ensure part is functional.	DAC 9 9-89	NOV 18 2014	
3	FINISHING	Touch-up alodine only	DAC 9 9-89	NOV 18 2014	
4	INSPECTION	QC7	W		
5	PAINT	Touch up primer as per QSI 005 Chapter 4.2.1 Record Batch: <u>128 927</u>	ER	14.11.18	1
6	INSPECTION	QC14	DAS 9 9-89	14.11.18	1
7	INSPECTION	QC5 Inspection Update label by engraving "A" against Mod No.	W	14.11.20	1
8	INSPECTION	QC21			
9	Packaging	Return completed part to original packaging.			

Rev	Date	Change Description	Prepared	Checked	Approved
A	14.10.28	New Issue	DD	PS	

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Rev. A

Approved (Pall Aerospace): Derek Harper
Position: Chief Engineer - Global Air Products

Signed:  Date: 29/10/14

DART AEROSPACE LTD	Work Order:	
Description: Repair Scheme MOD for ECR38646		
Drawing: QB21502	Repair Scheme:	RS1025
Part No: AIR FILTER QB21304	Page:	1 of 1
Batch No: SERIAL #'s: RA5-3455 TO RA5-3464 and RA5-5153 TO RA5-5158	Qty:	1

Step	Location	Procedure	By	Date	Qty
1	SMALL FAB	a) Record Serial Number: <u>RA5-3464</u> b) Protect filter to ensure debris generated by the repair cannot enter the panel. c) Using a reamer, enlarge 2 off holes 5.1/5.2mm to 6.5 mm +/-0.5mm, per Pall Aerospace ECR38646 attached. d) Ensure reamer has stop installed to prevent damage to anchor nut. e) Clean edge of hole. f) Remove any swarf.	JS	NOV 13 2014	1
2	INSPECTION	a) QC5 inspect holes, verify dimension, check anchor nut to ensure part is functional.	DAS 9 9-89	NOV 18 2014	
3	FINISHING	Touch-up alodine only	DAS 9 9-89	NOV 18 2014	
4	INSPECTION	QC7	✓		
5	PAINT	Touch up primer as per QSI 005 Chapter 4.2.1 Record Batch: <u>128 927</u>	CA	14.11.13	1
6	INSPECTION	QC14	DAS 9 9-89	14.11.13	1
7	INSPECTION	QC5 Inspection Update label by engraving "A" against Mod No.	✓	14/11/20	1
8	INSPECTION	QC21			
9	Packaging	Return completed part to original packaging.			

Rev	Date	Change Description	Prepared	Checked	Approved
A	14.10.28	New Issue	DD	PS	

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Rev. A

Approved (Pall Aerospace): Derek Harper
Position: Chief Engineer – Global Air Products

Signed:  Date: 27/10/14

DART AEROSPACE LTD	Work Order:	
Description: Repair Scheme MOD for ECR38646		
Drawing: QB21502	Repair Scheme:	RS1025
Part No: AIR FILTER QB21304	Page:	1 of 1
Batch No: SERIAL #'s: RA5-3455 TO RA5-3464 and RA5-5153 TO RA5-5158	Qty:	1

Step	Location	Procedure	By	Date	Qty
1	SMALL FAB	a) Record Serial Number: <u>RA5-3462</u> b) Protect filter to ensure debris generated by the repair cannot enter the panel. c) Using a reamer, enlarge 2 off holes 5.1/5.2mm to 6.5 mm +/-0.5mm, per Pall Aerospace ECR38646 attached. d) Ensure reamer has stop installed to prevent damage to anchor nut. e) Clean edge of hole. f) Remove any swarf.	FF	NOV 13 2014	1
2	INSPECTION	a) QC5 inspect holes, verify dimension, check anchor nut to ensure part is functional.	DAS 9 9-89	NOV 18 2014	
3	FINISHING	Touch-up alodine only	DAS 9 9-89	NOV 18 2014	
4	INSPECTION	QC7	✓		
5	PAINT	Touch up primer as per QSI 005 Chapter 4.2.1 Record Batch: <u>128 927</u>	CR	14.11.13	1
6	INSPECTION	QC14	DAS 9 9-89	14.11.13	1
7	INSPECTION	QC5 Inspection Update label by engraving "A" against Mod No.	✓	14.11.20	1
8	INSPECTION	QC21			
9	Packaging	Return completed part to original packaging.			

Rev	Date	Change Description	Prepared	Checked	Approved
A	14.10.28	New Issue	DD	PS	

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Rev. A

Approved (Pall Aerospace): Derek Harper
Position: Chief Engineer – Global Air Products

Signed:  Date: 27/10/14

DART AEROSPACE LTD	Work Order:	
Description: Repair Scheme MOD for ECR38646		
Drawing: QB21502	Repair Scheme:	RS1025
Part No: AIR FILTER QB21304	Page:	1 of 1
Batch No: SERIAL #'s: RA5-3455 TO RA5-3464 and RA5-5153 TO RA5-5158	Qty:	1

Step	Location	Procedure	By	Date	Qty
1	SMALL FAB	a) Record Serial Number: <u>PAS-3463</u> b) Protect filter to ensure debris generated by the repair cannot enter the panel. c) Using a reamer, enlarge 2 off holes 5.1/5.2mm to 6.5 mm +/-0.5mm, per Pall Aerospace ECR38646 attached. d) Ensure reamer has stop installed to prevent damage to anchor nut. e) Clean edge of hole. f) Remove any swarf.	FF	NOV 13 2014	1
2	INSPECTION	a) QC5 inspect holes, verify dimension, check anchor nut to ensure part is functional.	DAS 9 9-89	NOV 18 2014	
3	FINISHING	Touch-up alodine only	DAS 9 9-89	NOV 18 2014	
4	INSPECTION	QC7	W		
5	PAINT	Touch up primer as per QSI 005 Chapter 4.2.1 Record Batch: <u>128927</u>	CR	14.11.18	1
6	INSPECTION	QC14	DAS 9 9-89	14-11-18	1
7	INSPECTION	QC5 Inspection Update label by engraving "A" against Mod No.	W	14.11.20	1
8	INSPECTION	QC21			
9	Packaging	Return completed part to original packaging.			

Rev	Date	Change Description	Prepared	Checked	Approved
A	14.10.28	New Issue	DD	PS	

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Rev. A

Approved (Pall Aerospace): Derek Harper
Position: Chief Engineer - Global Air Products

Signed:  Date: 27/10/14

DART AEROSPACE LTD	Work Order:	
Description: Repair Scheme MOD for ECR38646		
Drawing: QB21502	Repair Scheme:	RS1025
Part No: AIR FILTER QB21304	Page:	1 of 1
Batch No: SERIAL #'s: RA5-3455 TO RA5-3464 and RA5-5153 TO RA5-5158	Qty:	1

Step	Location	Procedure	By	Date	Qty
1	SMALL FAB	a) Record Serial Number: <u>RA5-3464</u> b) Protect filter to ensure debris generated by the repair cannot enter the panel. c) Using a reamer, enlarge 2 off holes 5.1/5.2mm to 6.5 mm +/-0.5mm, per Pall Aerospace ECR38646 attached. d) Ensure reamer has stop installed to prevent damage to anchor nut. e) Clean edge of hole. f) Remove any swarf.	FF	NOV 13 2014	1
2	INSPECTION	a) QC5 inspect holes, verify dimension, check anchor nut to ensure part is functional.	DAS 9 9-89	NOV 18 2014	
3	FINISHING	Touch-up alodine only	DAS 9 9-89	NOV 18 2014	
4	INSPECTION	QC7	W		
5	PAINT	Touch up primer as per QSI 005 Chapter 4.2.1 Record Batch: <u>128927</u>	PA	14.11.18	
6	INSPECTION	QC14	DAS 9 9-89	14.11.18	1
7	INSPECTION	QC5 Inspection Update label by engraving "A" against Mod No.	W	14.11.20	1
8	INSPECTION	QC21			
9	Packaging	Return completed part to original packaging.			

Rev	Date	Change Description	Prepared	Checked	Approved
A	14.10.28	New Issue	DD	PS	

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Rev. A

Approved (Pall Aerospace): Derek Harper
Position: Chief Engineer – Global Air Products

Signed:  Date: 27/10/14

DART AEROSPACE LTD	Work Order:	
Description: Repair Scheme MOD for ECR38646		
Drawing: QB21502	Repair Scheme:	RS1025
Part No: AIR FILTER QB21304	Page:	1 of 1
Batch No: SERIAL #'s: RA5-3455 TO RA5-3464 and RA5-5153 TO RA5-5158	Qty:	1

Step	Location	Procedure	By	Date	Qty
1	SMALL FAB	a) Record Serial Number: <u>RA 5-5153</u> b) Protect filter to ensure debris generated by the repair cannot enter the panel. c) Using a reamer, enlarge 2 off holes 5.1/5.2mm to 6.5 mm +/-0.5mm, per Pall Aerospace ECR38646 attached. d) Ensure reamer has stop installed to prevent damage to anchor nut. e) Clean edge of hole. f) Remove any swarf.	FF	NOV 13 2014	1
2	INSPECTION	a) QC5 inspect holes, verify dimension, check anchor nut to ensure part is functional.	DAS 9 9-89	NOV 18 2014	
3	FINISHING	Touch-up alodine only	DAS 9 9-89	NOV 18 2014	
4	INSPECTION	QC7	W		
5	PAINT	Touch up primer as per QSI 005 Chapter 4.2.1 Record Batch: <u>128 927</u>	EA	14.11.13	
6	INSPECTION	QC14	DAS 9 9-89	14.11.13	1
7	INSPECTION	QC5 Inspection Update label by engraving "A" against Mod No.	W	14.11.20	1
8	INSPECTION	QC21			
9	Packaging	Return completed part to original packaging.			

Rev	Date	Change Description	Prepared	Checked	Approved
A	14.10.28	New Issue	DD	PS	

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Rev. A

Approved (Pall Aerospace): Derek Harper
Position: Chief Engineer - Global Air Products

Signed:  Date: 27/10/14

DART AEROSPACE LTD	Work Order:	
Description: Repair Scheme MOD for ECR38646		
Drawing: QB21502	Repair Scheme:	RS1025
Part No: AIR FILTER QB21304	Page:	1 of 1
Batch No: SERIAL #'s: RA5-3455 TO RA5-3464 and RA5-5153 TO RA5-5158	Qty:	1

Step	Location	Procedure	By	Date	Qty
1	SMALL FAB	a) Record Serial Number: <u>RA5-5154</u> b) Protect filter to ensure debris generated by the repair cannot enter the panel. c) Using a reamer, enlarge 2 off holes 5.1/5.2mm to 6.5 mm +/-0.5mm, per Pall Aerospace ECR38646 attached. d) Ensure reamer has stop installed to prevent damage to anchor nut. e) Clean edge of hole. f) Remove any swarf.	FF	NOV 13 2014	1
2	INSPECTION	a) QC5 inspect holes, verify dimension, check anchor nut to ensure part is functional.	DAS 9 9-89	NOV 18 2014	
3	FINISHING	Touch-up alodine only	DAS 9 9-89	NOV 18 2014	
4	INSPECTION	QC7	9-89		
5	PAINT	Touch up primer as per QSI 005 Chapter 4.2.1 Record Batch: <u>128 927</u>	CR	14.11.18	1
6	INSPECTION	QC14	DAS 9 9-89	14.11.18	1
7	INSPECTION	QC5 Inspection Update label by engraving "A" against Mod No.	W	14.11.20	1
8	INSPECTION	QC21			
9	Packaging	Return completed part to original packaging.			

Rev	Date	Change Description	Prepared	Checked	Approved
A	14.10.28	New Issue	DD	PS	

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Rev. A

Approved (Pall Aerospace): Derek Harper
Position: Chief Engineer - Global Air Products

Signed: _____

Date: 27/10/14

DART AEROSPACE LTD	Work Order:	
Description: Repair Scheme MOD for ECR38646		
Drawing: QB21502	Repair Scheme:	RS1025
Part No: AIR FILTER QB21304	Page:	1 of 1
Batch No: SERIAL #'s: RA5-3455 TO RA5-3464 and RA5-5153 TO RA5-5158	Qty:	1

Step	Location	Procedure	By	Date	Qty
1	SMALL FAB	a) Record Serial Number: <u>RA5-5155</u> b) Protect filter to ensure debris generated by the repair cannot enter the panel. c) Using a reamer, enlarge 2 off holes 5.1/5.2mm to 6.5 mm +/-0.5mm, per Pall Aerospace ECR38646 attached. d) Ensure reamer has stop installed to prevent damage to anchor nut. e) Clean edge of hole. f) Remove any swarf.	FF	NOV 13 2014	1
2	INSPECTION	a) QC5 inspect holes, verify dimension, check anchor nut to ensure part is functional.	DAS 9 9-89	NOV 18 2014	
3	FINISHING	Touch-up alodine only	DAS 9 9-89	NOV 18 2014	
4	INSPECTION	QC7	W		
5	PAINT	Touch up primer as per QSI 005 Chapter 4.2.1 Record Batch: <u>128927</u>	CR	14.11.14	1
6	INSPECTION	QC14	DAS 9 9-89	14.11.14	1
7	INSPECTION	QC5 Inspection Update label by engraving "A" against Mod No.	W	14.11.20	1
8	INSPECTION	QC21			
9	Packaging	Return completed part to original packaging.			

Rev	Date	Change Description	Prepared	Checked	Approved
A	14.10.28	New Issue	DD	PS	

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Rev. A

Approved (Pall Aerospace): Derek Harper
Position: Chief Engineer – Global Air Products

Signed:  Date: 27/10/14

DART AEROSPACE LTD	Work Order:	
Description: Repair Scheme MOD for ECR38646		
Drawing: QB21502	Repair Scheme:	RS1025
Part No: AIR FILTER QB21304	Page:	1 of 1
Batch No: SERIAL #'s: RA5-3455 TO RA5-3464 and RA5-5153 TO RA5-5158	Qty:	1

Step	Location	Procedure	By	Date	Qty
1	SMALL FAB	a) Record Serial Number: <u>RA5-5156</u> b) Protect filter to ensure debris generated by the repair cannot enter the panel. c) Using a reamer, enlarge 2 off holes 5.1/5.2mm to 6.5 mm +/-0.5mm, per Pall Aerospace ECR38646 attached. d) Ensure reamer has stop installed to prevent damage to anchor nut. e) Clean edge of hole. f) Remove any swarf.	FF	NOV 13 2014	1
2	INSPECTION	a) QC5 inspect holes, verify dimension, check anchor nut to ensure part is functional.	DAS 9 9-89	NOV 18 2014	
3	FINISHING	Touch-up alodine only	9 9-89	NOV 18 2014	
4	INSPECTION	QC7	✓		
5	PAINT	Touch up primer as per QSI 005 Chapter 4.2.1 Record Batch: <u>128 927</u>	CL	14.11.13	1
6	INSPECTION	QC14	DAS 9 9-89	14.11.13	①
7	INSPECTION	QC5 Inspection Update label by engraving "A" against Mod No.	u	14.11.20	1
8	INSPECTION	QC21			
9	Packaging	Return completed part to original packaging.			

Rev	Date	Change Description	Prepared	Checked	Approved
A	14.10.28	New Issue	DD	PS	

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Rev. A

Approved (Pall Aerospace): Derek Harper
Position: Chief Engineer – Global Air Products

Signed:  Date: 27/10/14

DART AEROSPACE LTD	Work Order:	
Description: Repair Scheme MOD for ECR38646		
Drawing: QB21502	Repair Scheme:	RS1025
Part No: AIR FILTER QB21304	Page:	1 of 1
Batch No: SERIAL #'s: RA5-3455 TO RA5-3464 and RA5-5153 TO RA5-5158	Qty:	1

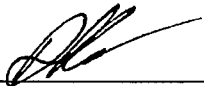
Step	Location	Procedure	By	Date	Qty
1	SMALL FAB	a) Record Serial Number: <u>RA5-5157</u> b) Protect filter to ensure debris generated by the repair cannot enter the panel. c) Using a reamer, enlarge 2 off holes 5.1/5.2mm to 6.5 mm +/-0.5mm, per Pall Aerospace ECR38646 attached. d) Ensure reamer has stop installed to prevent damage to anchor nut. e) Clean edge of hole. f) Remove any swarf.	FF	NOV 13 2014	1
2	INSPECTION	a) QC5 inspect holes, verify dimension, check anchor nut to ensure part is functional.	DAS 9 9-89 DAS	NOV 18 2014	
3	FINISHING	Touch-up alodine only	9 9-89	NOV 18 2014	
4	INSPECTION	QC7			
5	PAINT	Touch up primer as per QSI 005 Chapter 4.2.1 Record Batch: <u>128 927</u>	CA	14-11-18	1
6	INSPECTION	QC14	DAS 9 9-89	14-11-18	1
7	INSPECTION	QC5 Inspection Update label by engraving "A" against Mod No.	1	14-11-20	1
8	INSPECTION	QC21			
9	Packaging	Return completed part to original packaging.			

Rev	Date	Change Description	Prepared	Checked	Approved
A	14.10.28	New Issue	DD	PS	

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Rev. A

Approved (Pall Aerospace): Derek Harper
Position: Chief Engineer – Global Air Products

Signed:  Date: 27/10/14

DART AEROSPACE LTD	Work Order:	
Description: Repair Scheme MOD for ECR38646		
Drawing: QB21502	Repair Scheme:	RS1025
Part No: AIR FILTER QB21304	Page:	1 of 1
Batch No: SERIAL #'s: RA5-3455 TO RA5-3464 and RA5-5153 TO RA5-5158	Qty:	1

Step	Location	Procedure	By	Date	Qty
1	SMALL FAB	a) Record Serial Number: <u>KA5-5159</u> b) Protect filter to ensure debris generated by the repair cannot enter the panel. c) Using a reamer, enlarge 2 off holes 5.1/5.2mm to 6.5 mm +/-0.5mm, per Pall Aerospace ECR38646 attached. d) Ensure reamer has stop installed to prevent damage to anchor nut. e) Clean edge of hole. f) Remove any swarf.	ff	NOV 13 2014	1
2	INSPECTION	a) QC5 inspect holes, verify dimension, check anchor nut to ensure part is functional.	DAS 9 9-89	NOV 18 2014	
3	FINISHING	Touch-up alodine only	DAS 9 9-89	NOV 18 2014	
4	INSPECTION	QC7	✓		
5	PAINT	Touch up primer as per QSI 005 Chapter 4.2.1 Record Batch: <u>128927</u>	er	14.11.16	1
6	INSPECTION	QC14	DAS 9 9-89	14.11.18	✓
7	INSPECTION	QC5 Inspection Update label by engraving "A" against Mod No.	✓	14.11.20	1
8	INSPECTION	QC21			
9	Packaging	Return completed part to original packaging.			

Rev	Date	Change Description	Prepared	Checked	Approved
A	14.10.28	New Issue	DD	PS	

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Rev. A

Approved (Pall Aerospace): Derek Harper
Position: Chief Engineer - Global Air Products

Signed:  Date: 27/10/14

DART AEROSPACE LTD	Work Order:	
Description: Repair Scheme MOD for ECR38646		
Drawing: QB21502	Repair Scheme:	RS1025
Part No: AIR FILTER QB21304	Page:	1 of 1
Batch No: SERIAL #'s: RA5-3455 TO RA5-3464 and RA5-5153 TO RA5-5158	Qty:	1

Step	Location	Procedure	By	Date	Qty
1	SMALL FAB	a) Record Serial Number: <u>RA5-5161</u> b) Protect filter to ensure debris generated by the repair cannot enter the panel. c) Using a reamer, enlarge 2 off holes 5.1/5.2mm to 6.5 mm +/-0.5mm, per Pall Aerospace ECR38646 attached. d) Ensure reamer has stop installed to prevent damage to anchor nut. e) Clean edge of hole. f) Remove any swarf.	FF	NOV 13 2014	1
2	INSPECTION	a) QC5 inspect holes, verify dimension, check anchor nut to ensure part is functional.	DAS 9 9-89	NOV 18 2014	
3	FINISHING	Touch-up alodine only	DAS 9 9-89	NOV 18 2014	
4	INSPECTION	QC7	W		
5	PAINT	Touch up primer as per QSI 005 Chapter 4.2.1 Record Batch: <u>128 927</u>	CA	14.11.13	1
6	INSPECTION	QC14	DAS 9 9-89	14.11.13	①
7	INSPECTION	QC5 Inspection Update label by engraving "A" against Mod No.	W	14.11.2014	
8	INSPECTION	QC21			
9	Packaging	Return completed part to original packaging.			

Rev	Date	Change Description	Prepared	Checked	Approved
A	14.10.28	New Issue	DD	PS	

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Rev. A

Approved (Pall Aerospace): Derek Harper
Position: Chief Engineer – Global Air Products

Signed:  Date: 29/10/14

DART AEROSPACE LTD	Work Order:	
Description: Repair Scheme MOD for ECR38646		
Drawing: QB21502	Repair Scheme:	RS1025
Part No: AIR FILTER QB21304	Page:	1 of 1
Batch No: SERIAL #'s: RA5-3455 TO RA5-3464 and RA5-5153 TO RA5-5158	Qty:	1

Step	Location	Procedure	By	Date	Qty
1	SMALL FAB	a) Record Serial Number: <u>RA5-3455</u> b) Protect filter to ensure debris generated by the repair cannot enter the panel. c) Using a reamer, enlarge 2 off holes 5.1/5.2mm to 6.5 mm +/-0.5mm, per Pall Aerospace ECR38646 attached. d) Ensure reamer has stop installed to prevent damage to anchor nut. e) Clean edge of hole. f) Remove any swarf.	FF	NOV 13 2014	1
2	INSPECTION	a) QC5 inspect holes, verify dimension, check anchor nut to ensure part is functional.	DAS 9 9-89 DAS	NOV 18 2014	
3	FINISHING	Touch-up alodine only	9 9-89	NOV 18 2014	
4	INSPECTION	QC7	W	NOV 18 2014	
5	PAINT	Touch up primer as per QSI 005 Chapter 4.2.1 Record Batch: <u>128927</u>	PR	14.11.13	1
6	INSPECTION	QC14	DAS 9 9-89	14.11.13	①
7	INSPECTION	QC5 Inspection Update label by engraving "A" against Mod No.	W	14.11.20	1
8	INSPECTION	QC21			
9	Packaging	Return completed part to original packaging.			

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A	14.10.28	New Issue	DD	PS	

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Rev. A

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